

Date: Tuesday, 15/07/2008 4:19:50 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	TOW RING
Job Number :	40529		
Estimate Number :	10794		
P.O. Number :		Part Number :	D3407041
This Issue :	15/07/2008	Drawing Number :	D3407/REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	C
Previous Run :	35780	Material :	
Written By :		Due Date :	30/07/2008
Checked & Approved By :	JUD 08.7.16	Qty:	20 Um: Each
Comment :	Est Rev:A 05.10.14 New issue KJ/EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34071	Stem
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3407-1	Stem	B37145

EL 8-8-14 (20)

2.0	D34075	Ring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3407-5	Ring	B34708

EL 8-8-14 (20)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D3407-3/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004

A/R TIG174 ROD Batch: M18774

CP108-08-14
EL 8-8-14

4.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

10 08-08-14 (20)

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

1080814 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:19:50 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOW RING

Job Number: 40529

Part Number: D3407041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M108523



(2x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Threaded Section

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:50
4:00
11:20

m.f 08/08/18

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-18

(K2c)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 466

AS 08/08/19 (K2c)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2019

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

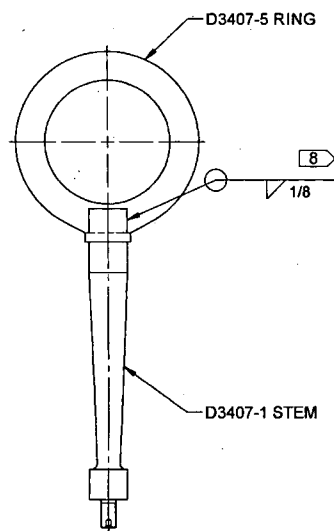
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

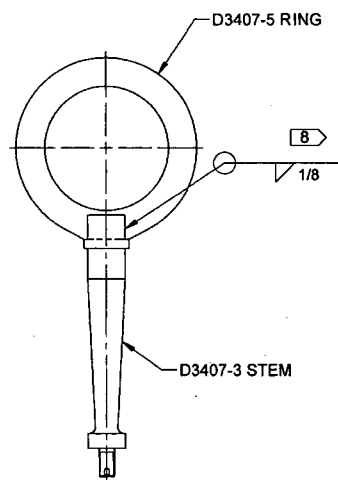
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

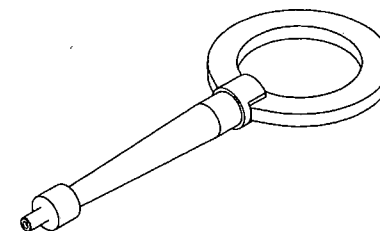
QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X		D3407-041	TOW RING
	X	D3407-043	TOW RING
1		D3407-1	STEM
1	1	D3407-3	STEM
1	1	D3407-5	RING



D3407-041 TOW RING



D3407-043 TOW RING



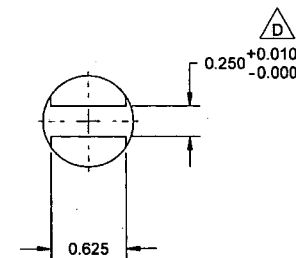
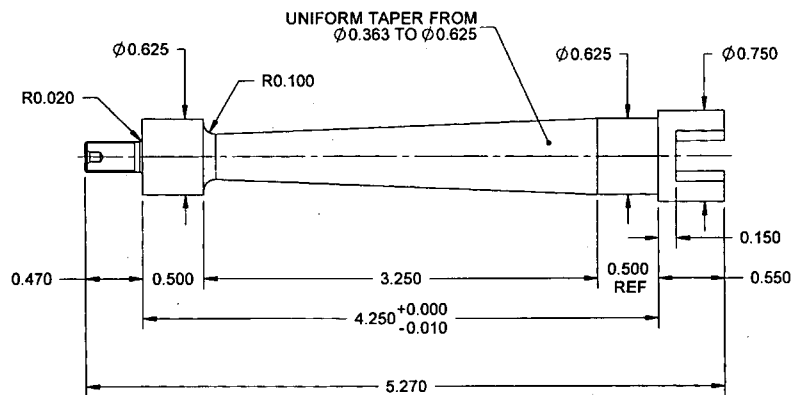
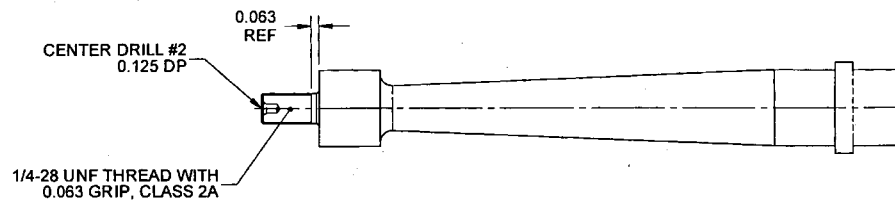
RELEASED
0805-13-14

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

NO. 20501
WORK ORDER
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FOR COPY
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REV.	DESCRIPTION	BY	DATE
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	DRAWING NO. D3407		
CHECKED	REV. D		
MFG. APPR.	SHEET 1 OF 4		
APPROVED	TITLE TOW RING		
DE APPR.	SCALE NTS		
DATE	08.04.07		

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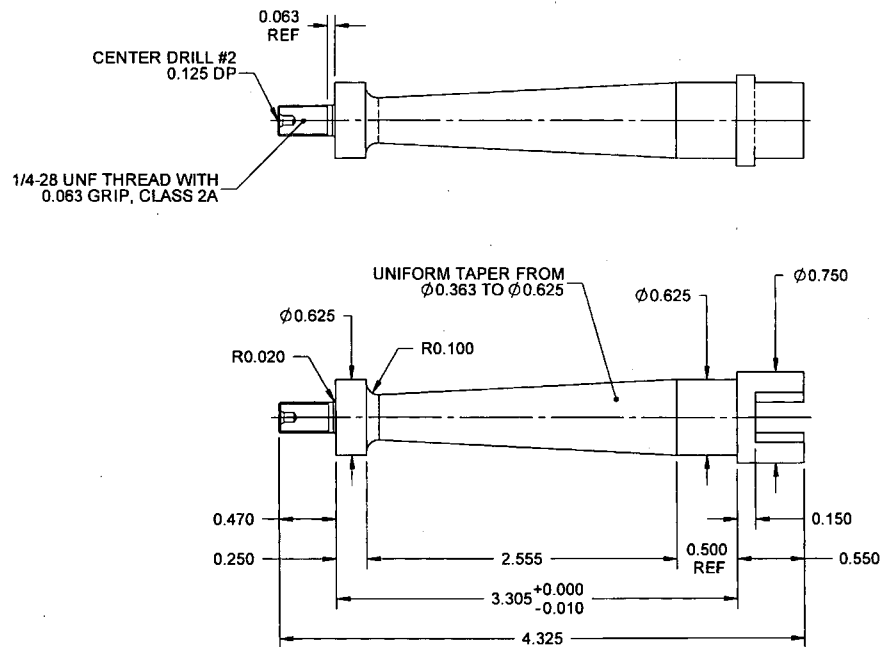
D3407-1 STEM

RELEASED
08-05-13

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3407	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.04.07	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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NO. 40539



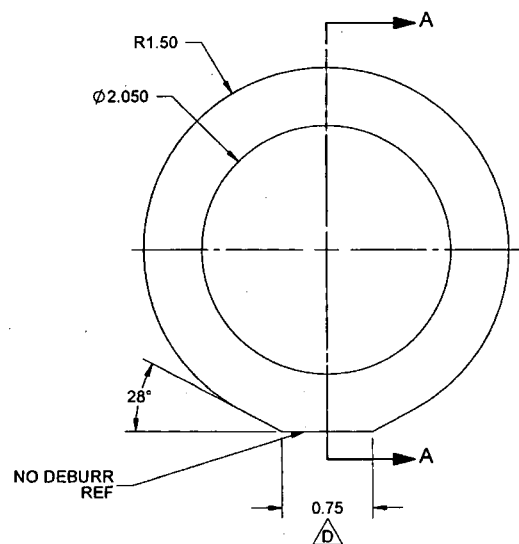
D3407-3 STEM

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A

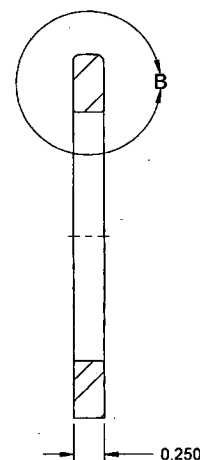
NO. 10501
 WORK ORDER
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DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3407	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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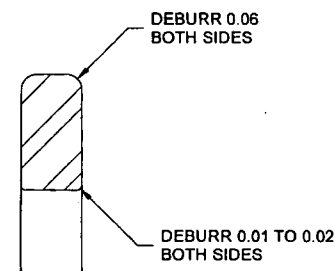
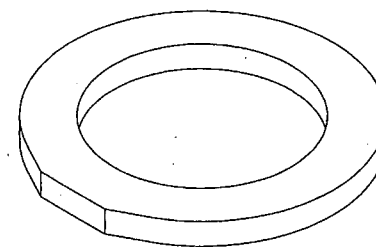
RELEASED
 08.05.13



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

RELEASED
08-05-13

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAKS SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.037 lbs

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	24	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3407	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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NO WORK ORDER
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L Lacelle

From: Peter Hum [phum@dartaero.com]
Sent: August 13, 2008 10:58 AM
To: 'L Lacelle'
Subject: RE: D3407-041

The only difference between Rev. D and Rev. C is the addition of the D3407-045 Tow Ring. D3407-041 and D3407-043 have not changed for Rev. D.....(i.e. D3407-041/-043 @ Rev. C = D3407-041/-043 @ Rev. D).

Peter

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, August 13, 2008 10:55 AM
To: 'Peter Hum'
Subject: D3407-041

Peter,
We have an open w./o D3407-041 at Rev.C, but the drwg is at rev.D...can you please help??

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

13/08/2008